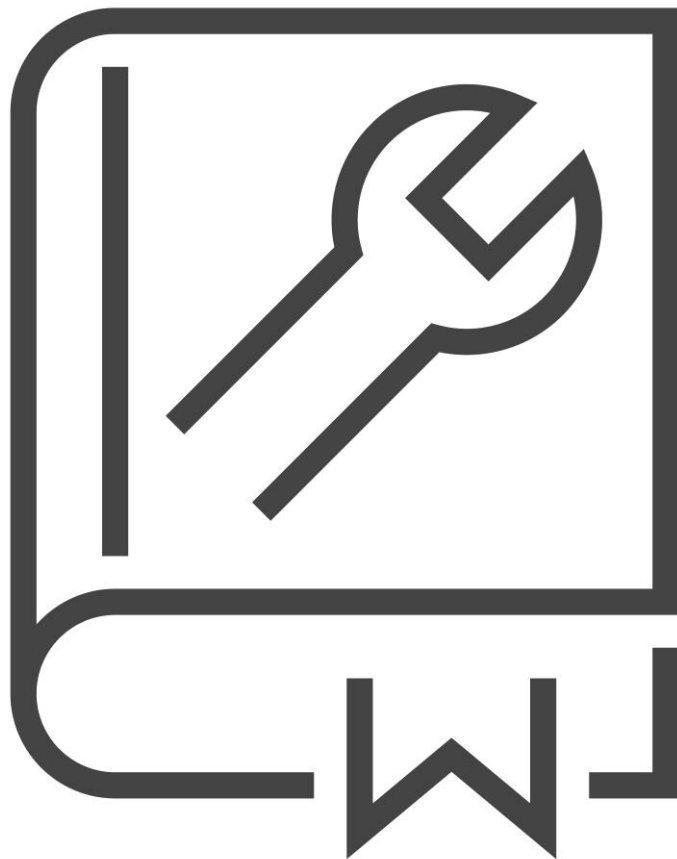




We are aluminium

Installation manual cast pieces



Introduction

The purpose of this manual is to provide instructions so that installers and service operatives can competently and safely assembly and maintain Hydro cast pieces.

Installers and service operatives must have the required competencies, knowledge and experience to safely work on equipment and operate mechanical tooling needed for the installation or maintenance of the cast pieces.



ATTENTION:

- Read this manual carefully before assembly.
- Always follow the instructions in this manual.
- Always wear personal protection equipment; helmet, boots, gloves and safety glasses.
- The fasteners must be clean and free from burrs, strange metal parts and casting sand.
- Due care must be taken not to exceed the torque settings stated in table 1 to prevent catastrophic component damage.
- Air tools should not be used because the fasteners can score due to the relatively high speed of the operation. This also counts when these tools are adjustable. The same goes for electrical tools, but when they can be adjusted at the right tightening moment, these tools can be used. We recommend "Never-Seez" lubricant for stainless fasteners.

Disclaimer

Despite the careful development and compilation of this installation manual, it is possible that incorrect or incomplete information is included. Hydro is not liable for any damage, directly or indirectly, related to the use of the information in this manual.

Maximum tightening moments for stainless fasteners	
Bold dimension (A2 class 70)	Tightening moment Nm
M10	35
M12	50
M16	100
M18	125

Table 1



Assembly cast pieces for brackets

- Check if the grub screws are greased
- Don't use air tools for fastening
- Max. torque setting for grub screws **M10** is 22Nm



Assembly invisible joint

- Check if the grub screws are greased
- Don't use air tools for fastening
- Max. torque setting for grub screws **M8** is 12Nm
- Mount the bracket before the installation of the column (This will help alignment of the column).



⚠ Attention: The bracket can be placed and mounted in 4 positions relative to the door. The mounting position can't be taken from the drawing, because there it is always drawn at 90° relative to the door. The right mounting position can be taken from the strength calculation. If this info is not available, then the position can be taken from the sticker on the delivered columns. If this says "NK"; "Free choice", then 180° or 0° is recommended.



⚠ Attention: poles are not installed immediately after delivery, we recommend removing the screws of the invisible joint and mounting these again until installation. This prevents the screws to get stuck because of external influences.